

# Work Order ID 161514

Thursday, May 18, 2017 8:25:29 AM

*Blue*  
\*161514\*

Page 1

Item ID: D2646BL Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Aft Cap  
 Start Date: 5/17/2017 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 5/23/2017 Req'd Qty: 12.00 \*12\* Customer:

Reference: *Rework*

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2646    | Rev C        |

160 0.00 **DAS 41**  
**\*160\*** 12 **9-89**  
 SprayPaint  
 Spray Painting Memo 0.00  
 PULL FROM STOCK:  
 12 X D2646 B 159719  
 SCUFF LIGHTLY  
 PRIME B 137487  
 SPRAY PAINT BLUE DELFLEET  
 BATCH: 137563  
 CLEAR DELFLEET B 137455  
**JUN 09 2017**

170 0.00 **DAS 38**  
**\*170\*** 12 **9-89**  
 QC Memo 0.12  
 Quality Control  
**JUN 14 2017**

**\*161514\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*12\***

**\*12\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

180

0.00

**\*180\***

## Small Fab

0.17

### Small Fab

## Memo

## Small Fab

Install inserts as per Dwg D2646

190

QC5- Inspect part completeness to step on W/O

0,00

**\*190\***

QC

## Memo

0.24

## Quality Control

200

Identify as per dwg & Stock Location: 17-001

0.00

**\*200\***

## Packaging

## Memo

0.12

## Packaging

LOCATION : FP001

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**\*161514\***

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Item ID: D2646BL Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Aft Cap  
Start Date: 5/17/2017 Start Qty: 12.00 **\*12\*** Cust Item ID:  
Required Date: 5/23/2017 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 210                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*210*</b>                   |                                             |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                        | 1.20                 |         |        |              |               |               |                  |                |
| Quality Control                |                                             |                      |         |        |              |               |               |                  |                |

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# Picklist Print

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Thursday, May 18, 2017 8:25:27 AM

Work Order ID: 161514

\*161514\*

Parent Item: D2646BL

\*D2646BL\*

Parent Item Name: Aft Cap

Start Date: 5/17/2017

Required Date: 5/23/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: G05.08.22Hole size revised in Step 5KJ/JLM  
 IPP Rev:H Changed Inserts 07-02-19 JLM  
 IPP rev I changed inserts 07.06.11 EC IPP REV:J  
 15.10.09 ADDED BL DD VERF:JLM

| Component Item ID/<br>Item Name    | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| ALS7-1032-130                      | AELS8-1032-130         | Purchased     | No          |                     |                  | 110             | Each               | 2,507.000      | 2           | 24           |               |                |        |
| *AI S7-1032-130* X ALS4-1032-130 / |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
| Rivnut                             |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FG       | 100     |          |
| M128649  | 50      |          |
| M136048  | 50      |          |
| FP001    | 2199    |          |
| M128649  | 155     |          |
| M136579  | 2044    |          |
| ST556    | 208     |          |
| M136048  | 208     |          |

D2646 Manufactured No

\*D2646\*

Aft Cap

B: 159719

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FG       | 4       |          |
| 85848    | 2       |          |
| 90495    | 2       |          |
| FP001    | 14      |          |
| 136885   | 3       |          |
| 149748   | 1       |          |
| 154440   | 10      |          |

\*\*

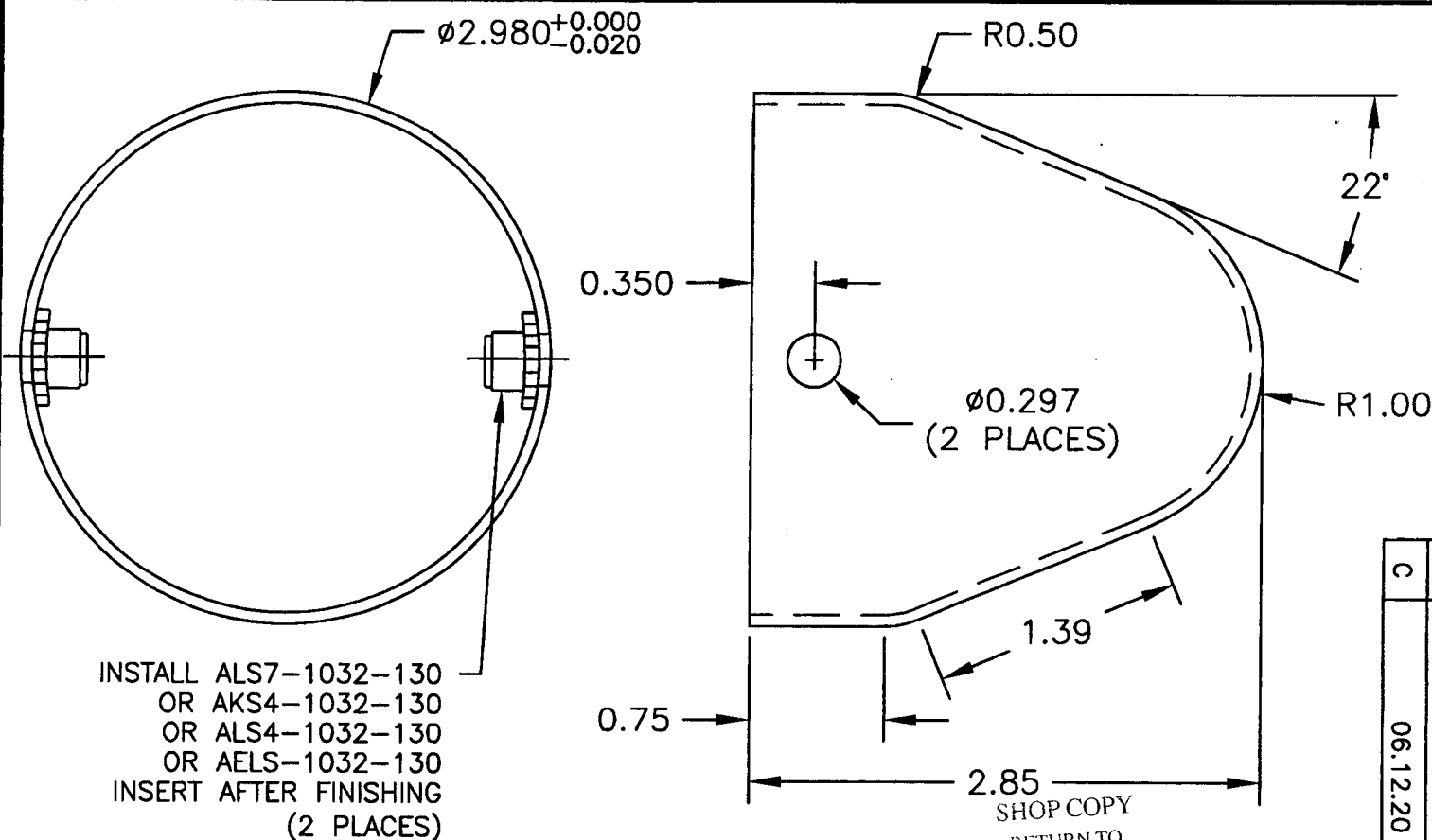
2/12

DAS  
41  
9-89

JUN 19 2017



| DESIGN  | DS       | DRAWN BY                     | PH    | DART AEROSPACE USA, INC. |
|---------|----------|------------------------------|-------|--------------------------|
| CHECKED |          | APPROVED                     |       | PORT HADLOCK, WA         |
| DATE    | 06.12.20 | TITLE                        | D2646 | REV. C                   |
|         |          | AFT CAP                      |       | SHEET 1 OF 1             |
|         |          |                              |       | SCALE                    |
|         |          |                              |       | 1:1                      |
| A       | 97.03.25 | NEW ISSUE                    |       |                          |
| B       | 05.04.01 | CHANGE TO CLOSED INSERTS     |       |                          |
| C       | 06.12.20 | CHANGE TO OPEN ENDED INSERTS |       |                          |



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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

RELEASED  
07.02.20

#### D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1) NO. 161514 MWS
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 1705-17  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED